

# Work Order ID 55903

February 04, 2010 10:06:23 AM



Page 1

Item ID: D117-762-011

Accept



Setup Start



Revision ID:

Item Name: Skidtube

Stop



Start Date: 02/04/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 02/11/2010 Req'd Qty: 2.00



Customer:

Reference: NCR10-011 Re-work

Approvals: Process Plan:

Date: 10-02-04

Tooling:

Date:

Run Start



QC:

Date: 10-02-04

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
N/A	Rev A								

100

0.00



QC

Quality Control

Memo

Pull from stock per NCR10-011  
1x B54149  
1x B54150  
and have re-worked.

0.00

= > m.k 10/02/16

(2x)

110

Assemble as per dwg

0.00



HandFinish

Hand Finishing

Memo

-Remove the D3508-9 wearplate & re-work per attached NCR w/o sheet.  
\*\*Ensure the slot is made square: 0.300" x 0.360"(maximum) towards the centerline on the most forward holes only.

0.00

> DP

10-2-11

-Debur the wearplate & touch up grey.

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

S1010116

(10)

130



HandFinish

Hand Finishing

Assemble as per dwg

0.00

Memo

Assemble the wearplate back onto the tube.

0.00

=&gt; M-h 10/02/16

(2X)

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

S1010116

(12)

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Customer:

Reference: NCR10-011 Re-work

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  Packaging Packaging	Identify as per dwg & Stock Location: _____ <i>NA A</i>  Memo Ensure the correct tube goes back into the correctly identified box.  Also ensure the corresponding kit & paperwork is included.  Re-stock using the original batch #	0.00  0.00							<i>10/04/18</i> <i>D</i>
160  QC Quality Control	QC21- Final Inspection - Work Order Release  Memo Add a copy of this w/o to the original w/o's as a reference.	0.00  0.00							<i>10/02/23</i> <i>J</i>  <i>mf</i> <i>10-2-22</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D117-762-041 PAR #: 7 <sup>See NCR 10-011</sup> Fault Category: Prod. Skid tubes NCR: Yes ☒ No ☐ DQA: 7 Date: 10.02.04

Resolution: re-work Disposition: re-work QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: 10-011		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10.02.04	250	Upon Assembly of the D3508-9 wear plate, it was noticed that the holes in the tube were too narrow and causing the wear plate to lift in the center when tightened.	<u>QSI/042</u>	Drill jig fuel hole angle slightly changed (came in) with use, due to mild O.D crushing on the tube from bending. DT8974 is Reworked.	<u>See NCR 10-011</u>	<u>7/10.02.04</u>	<u>QSI/042</u>	<u>7/10.02.04</u>
		R.C. Tooling.	<u>CP</u> <u>10.02.04</u> <u>QSI/042</u>	On the 2 most fuel holes on the D3508-9 wear plate, slot the holes, square, to max 0.060" (or as necessary), to allow the bolts to tighten	<u>CP</u> <u>10-2-10</u>	<u>S</u> <u>10/02/10</u>	<u>CP</u> <u>10.02.04</u> <u>QSI/042</u>	<u>7/10.02.04</u>
			<u>CP</u> <u>10.02.04</u> <u>QSI/042</u>	without any bending up of the wear plate 0.300 x 0.360 max eng. & open/slot, square to 0.060" maximum towards center line.	<u>CP</u> <u>10-2-10</u>	<u>S</u> <u>10/02/10</u>	<u>CP</u> <u>10.02.04</u> <u>QSI/042</u>	<u>7/10.02.04</u>

NOTE: Date & initial all entries